

Stainless Steel Flux Cored Wire

GMX2209

AWS A5.22 E2209T1-1/4
A5.22M E2209T1-1/4
JIS Z 3323 TS2209-FB1
ISO 17633-A-T 22 9 3 NLP C1, M21 1

Product Features:

- GMX2209 is design to weld similar type of duplex stainless steel.
- The alloy has good resistance to stress corrosion cracking and pitting corrosion attack.
- Smooth arc, low spatter loss and easy slag removal.

Applications:

- Suitable for welding of duplex stainless steel such as 2205.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	Fe	N
0.03	0.60	1.50	9.10	23.1	3.2	Bal.	0.16

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
620	810	28

Size (mm) & recommended welding parameters

Diameter		1.2mm	1.6mm
Polarity		DC+	DC+
Ampere (A)	Flat position	160~250	220~300
	Vertical up position	90~130	----
Shielding Gas		CO ₂ /80%Ar+20%CO ₂	CO ₂ /80%Ar+20%CO ₂

Note:

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
All Right Reserved

GOOD
GOODWELD
www.goodweld.com.tw